

Date: Wednesday, 28/01/2009 5:10:28 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARSHOE
Job Number	: 45355		
Estimate Number	: 13315		
P.O. Number	:	Part Number	: D37933
This Issue	: 28/01/2009 S.O. No. :	Drawing Number	: D3793 REVA
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	: 44913	Material	:
Written By	:	Due Date	: 06/02/2009 Qty: 20 Um: Each
Checked & Approved By	: <u>JUL 09.01.29</u>		
Comment	: Est Rev:A 08-05-13 new issue DD verified by:EC Est Rev:B 08-05-23 revA as per dwg DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S20GA	304/316 .040 Sheet
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Comment: Qty.: 1.3469 sf(s)/Unit Total : 26.9388 sf(s)
 304/316 .040 Sheet
 (M304S20GA)
 Batch: 110076 18 9-2-10

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3793
 Dwg Rev: A
 Prog Rev: A

18 9-2-10

2-Deburr if necessary 18 9-2-10



3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

S 09/02/11 (X20) counters

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
 1-Deburr if necessary

2-Form on Brake as per Dwg D3793 using Jigs

SB 09/02/11



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 28/01/2009 5:10:28 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 45355

Part Number: D37933

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/02/11 (20)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref. 4.3.5.6) as per QSI 005 4.3

M 109648

START TIME:

9:15

OVEN TEMPERATURE:

320°

FINISH TIME:

9:45

BR 09-02-12

(20)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 09/02/12

(20)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FP-18

BR 0902-12

(20)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/13

Job Completion



MF 09-02-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 45355
Description: Wearshoe		Part Number: D3793-3
Inspection Dwg: D3793	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.188	+0.005/-0.001	.192	✓			
0.300 x 0.300	+/-0.010	305 x 306	✓			
1.885	+/-0.010	1.888	✓			
4.389	+/-0.010	4.382	✓			
6.547	+/-0.010	6.541	✓			
6.00	+/-0.030	5.999	✓			
6.75	+/-0.030	6.752	✓			
2.000	+/-0.010	1.999	✓			
4.750	+/-0.010	4.749	✓			
9.500	+/-0.010	9.500	✓			
14.250	+/-0.010	14.255	✓			
17.750	+/-0.010	17.750	✓			
26.735	+/-0.010	26.735	✓			
Ø0.531 x 0.780	+0.008/-0.001	532 x 782	✓			

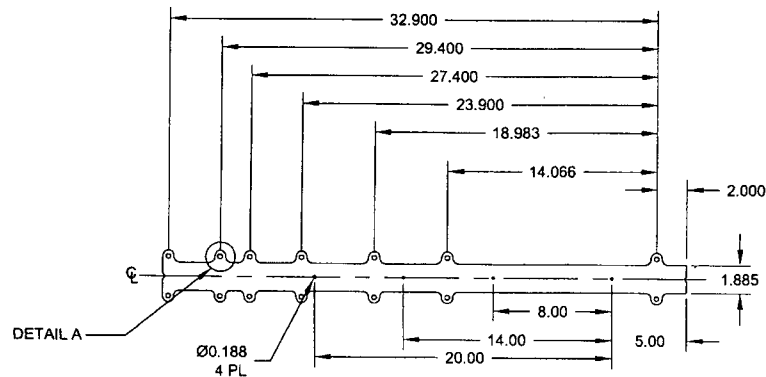
Measured by: JB
Date: 9-2-10

Audited by: S
Date: 09/02/11

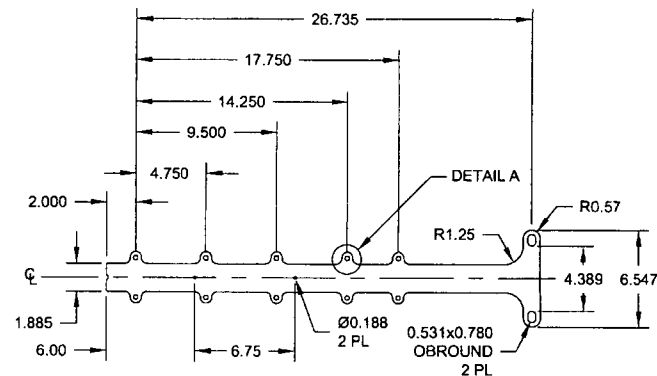
Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.05.30	New Issue	KJ/DD	

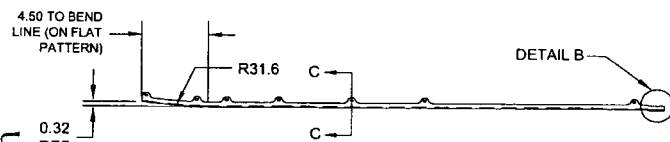
8 7 6 5 4 3 2 1



D3793-1F FLAT PATTERN



D3793-3F FLAT PATTERN



D3793-1 BEND DETAIL
(MAKE FROM D3793-1F)



D3793-3 BEND DETAIL
(MAKE FROM D3793-3F)

RELEASED
08.05.14

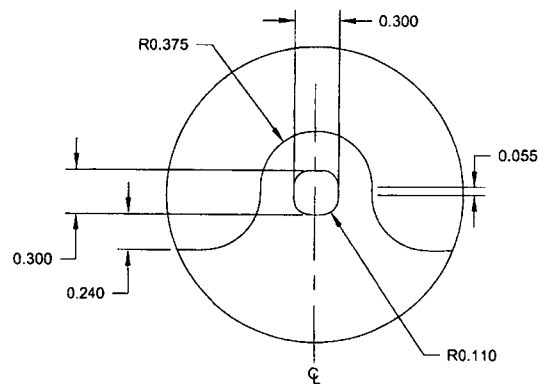
NO 15355
WORK CENTER
WITHOUT NAME
SUBJECT TO ASSIGNMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

NOTES:

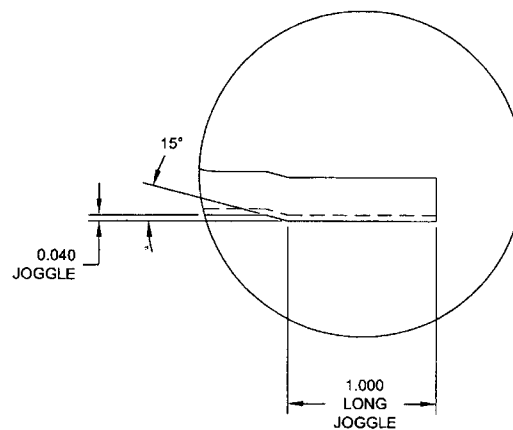
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXXX-X" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: D3793-1 - 0.72 LBS, D3793-3 - 0.66 LBS

A		NEW ISSUE		PH	08.05.14
REV.		DESCRIPTION		BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA			
DRAWN	PH				
CHECKED		DRAWING NO.	REV. A		
MFG. APPR.		D3793	SHEET 1 OF 2		
APPROVED		TITLE	SCALE		
DE APPR.		WEARSHOE	NTS		
DATE	08.05.14	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			

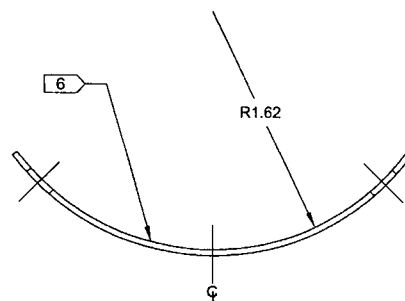
8 7 6 5 4 3 2 1



DETAIL A
SCALE 10X



DETAIL B
SCALE 10X



SECTION C-C
SCALE 10X

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WITHOUT
WORK ORDER
NO 45355

RELEASED
08-05-23/100

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	DS	DRAWING NO.	REV. A
MFG. APPR.	DS	D3793	SHEET 2 OF 2
APPROVED	DS	TITLE	SCALE
DE APPR.	DS	WEARSHOE	NTS
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8 7 6 5 4 3 2 1